

Date: Thursday, 10/11/2007 2:54:48 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STIFFNER
Job Number	: 35128		
Estimate Number	: 12955		
P.O. Number	: N/A	Part Number	: D36391
This Issue	: 10/11/2007 S.O. No. : N/A	Drawing Number	: D3639 UNDER REVIEW
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: N/A
Previous Run	: 34538	Material	: N/A
Written By	: [Signature]	Due Date	: 10/18/2007
Checked & Approved By	: [Signature] 07.10.12	Qty:	10 Um: Each
Comment	: Est Rev. A New Issue 07-07-20 JLM	Verified By:	EC



Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S050	2024-T3 .050 sheet
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Comment: Qty.: 0.2510 sf(s)/Unit Total : 2.5095 sf(s)
2024-T3 .050 sheet
Batch: 105646 B 07-10-15

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
1-Cut as per Dwg D3639
Dwg Rev: A B 07-10-15
Prog Rev: A
2-Deburr if necessary B 07-10-15

(10)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

count 07/10/15 (+10)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE
Form as per Dwg D3639

07/12/20

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: AD Date: 01/21/24
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/11/2007 2:54:48 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STIFFNER

Job Number: 35128

Part Number: D36391

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/12/21 (X10)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

07-12-21

(X10)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/12/21

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: ST 261

07/12/21

X10

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/12/21

Job Completion



07.12.21

POSITIVE RECALL

EFFECTIVE

AUTH

RELEASED

DATE

07-10-15

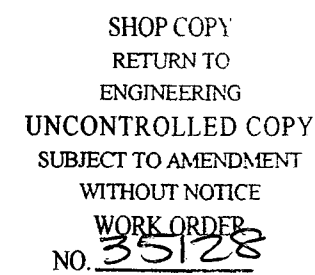
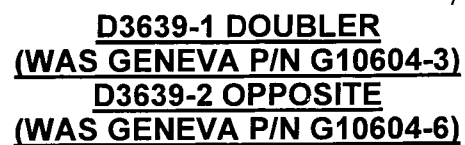
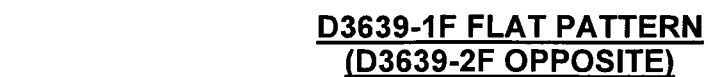
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

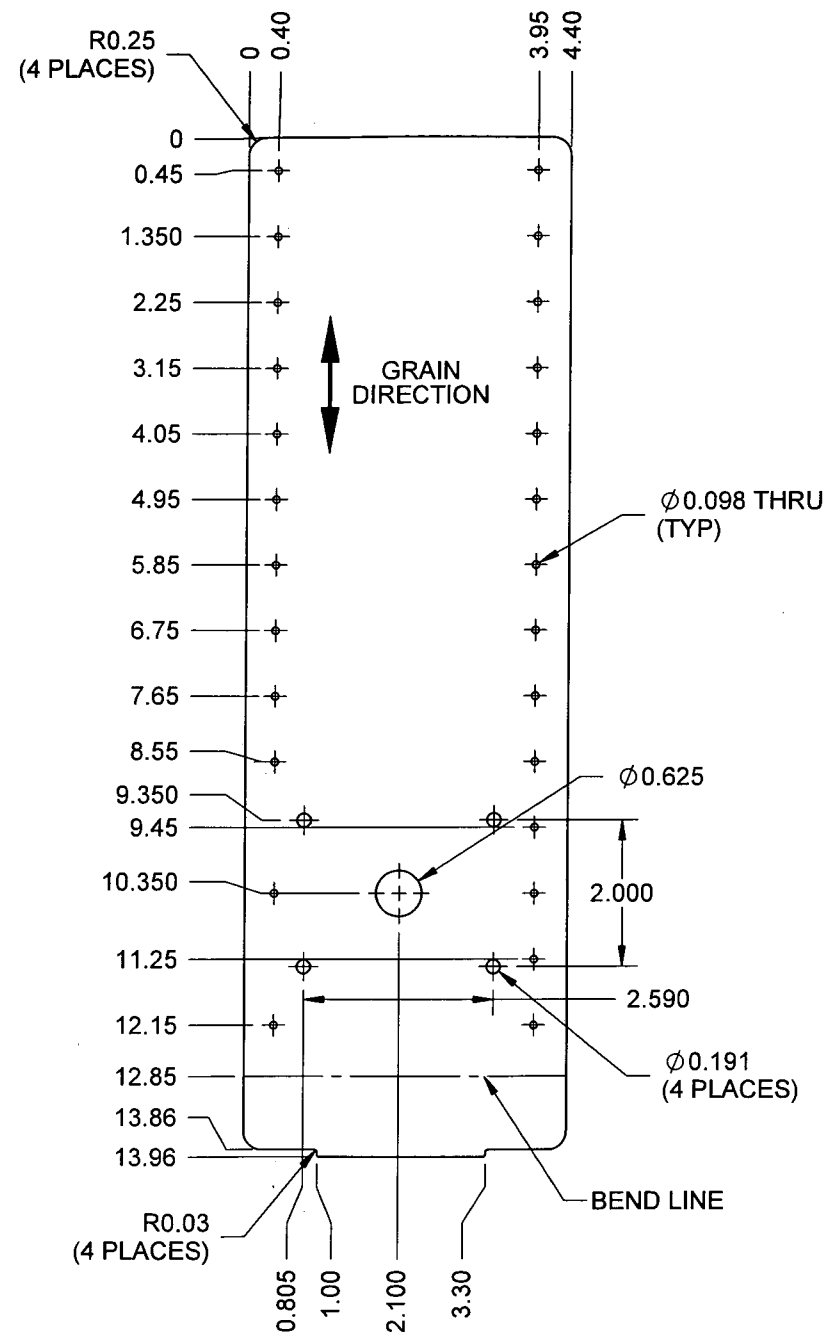


PRELIMINARY ISSUE
ME 02/10/12

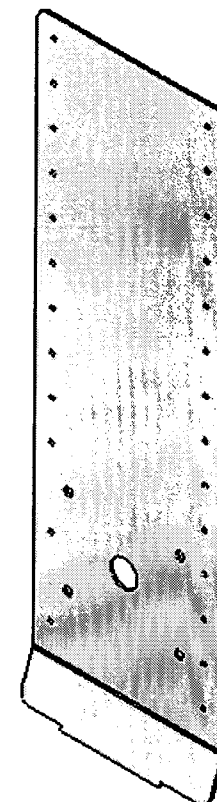
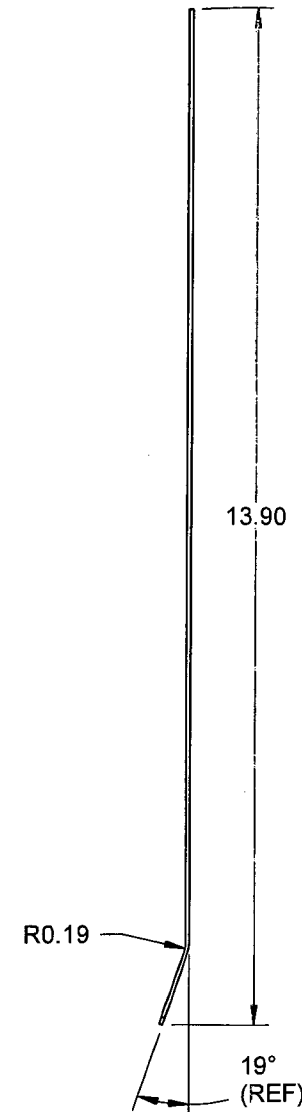
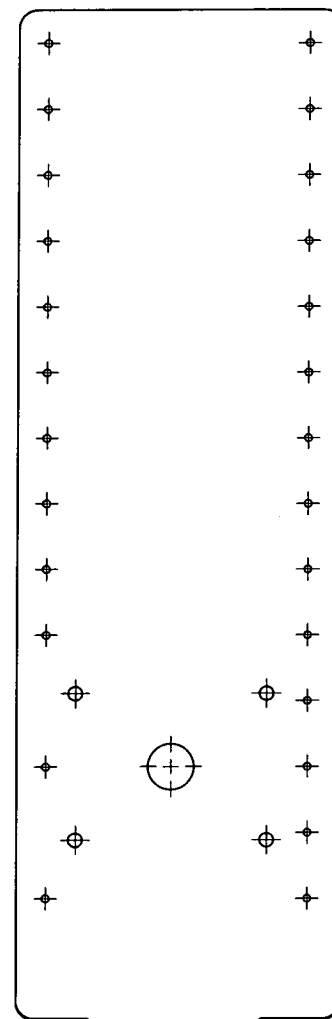
NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037
(REF DART SPEC M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3639-1/-2" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.14 lbs

A	NEW ISSUE; REPLACES G10604	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	TS	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	LE		
CHECKED	B	DRAWING NO.	REV. A
MFG. APPR.	E	D3639	SHEET 1 OF 2
APPROVED	40	TITLE	SCALE
DE APPR.	#	DOUBLER	2:3
DATE	07.07.27	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



**D3639-3F FLAT PATTERN
(D3639-4F OPPOSITE)**



**D3639-3 DOUBLER
(WAS GENEVA P/N G10604-4)
D3639-4 OPPOSITE
(WAS GENEVA P/N G10604-5)**

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WORK ORDER
NO. 35128

PRELIMINARY ISSUE
07.07.27

- NOTES:**
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3639-3/-4" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.3 lbs

DESIGN	TS	DART AEROSPACE USA, INC.	
DRAWN	CE	PORT HADLOCK, WA	
CHECKED	EB	DRAWING NO.	REV. A
MFG. APPR.	EB	D3639	SHEET 2 OF 2
APPROVED	MD	TITLE	SCALE
DE APPR.	AF	DOUBLER	2:5
DATE	07.07.27	<small>COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

DART AEROSPACE LTD		Work Order: 35128
Description: STIFFNER		Part Number: D 3639-1
Inspection Dwg: D3639	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

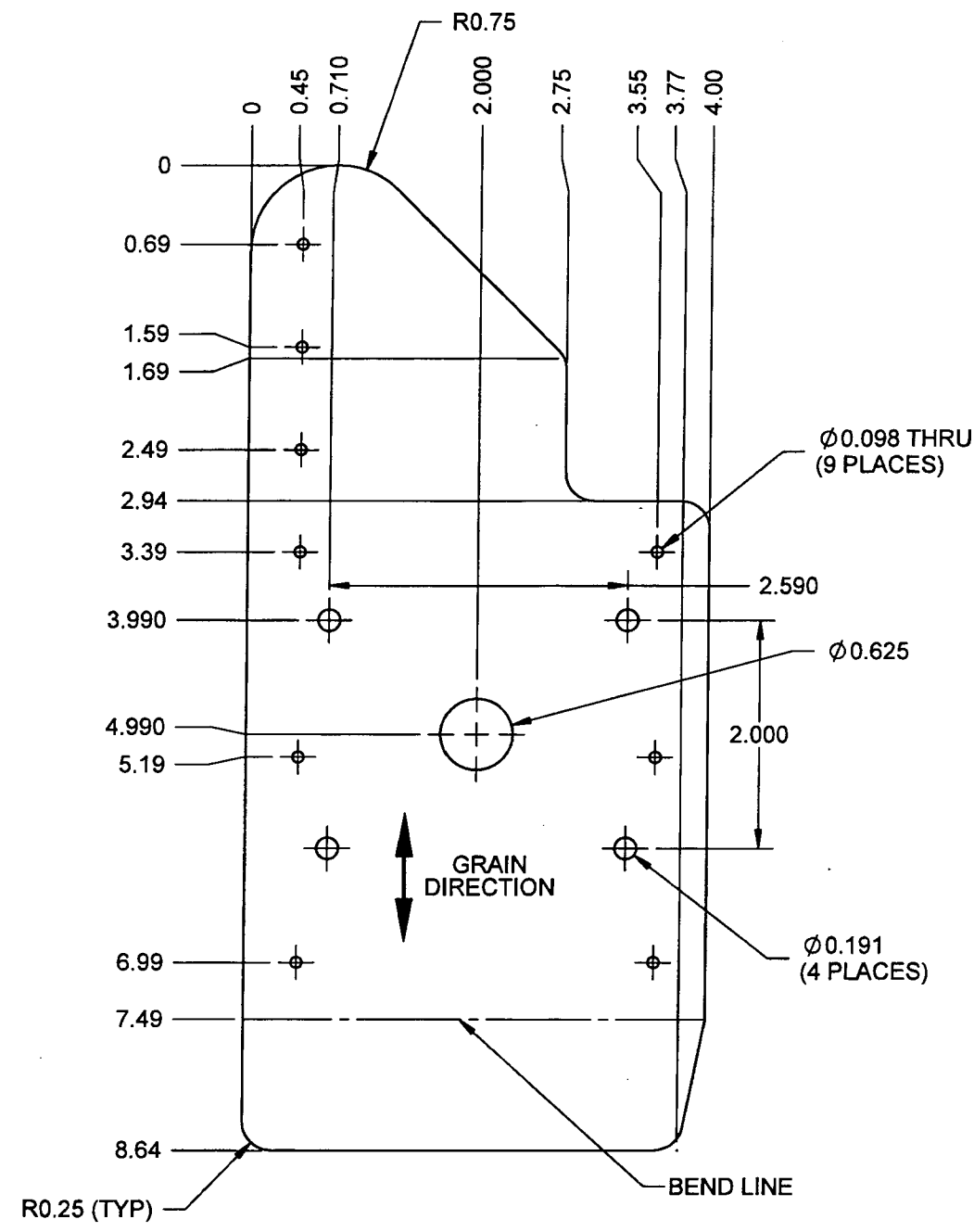
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .625	+ .008 - .001	.625	X			
Ø .191	+ .005 - .001	.191	X			
Ø .098	+ .004 - .001	.098	X			
.45	± .030	.45	X			
.710	± .010	.710	X			
2.000	± .010	2.000	X			
2.75	± .030	2.757	X			
3.55	± .030	3.55	X			
4.00	± .030	4.00	X			
.69	± .030	.69	X			
1.59	± .030	1.59	X			
2.49	± .030	2.49	X			
2.94	± .030	2.94	X			
3.39	± .030	3.39	X			
3.990	± .010	3.990	X			
4.990	± .010	4.990	X			
5.19	± .030	5.19	X			
6.99	± .030	6.99	X			
8.64	± .030	8.64	X			
2.00	± .030	2.00	X			
2.590	± .010	2.590	X			

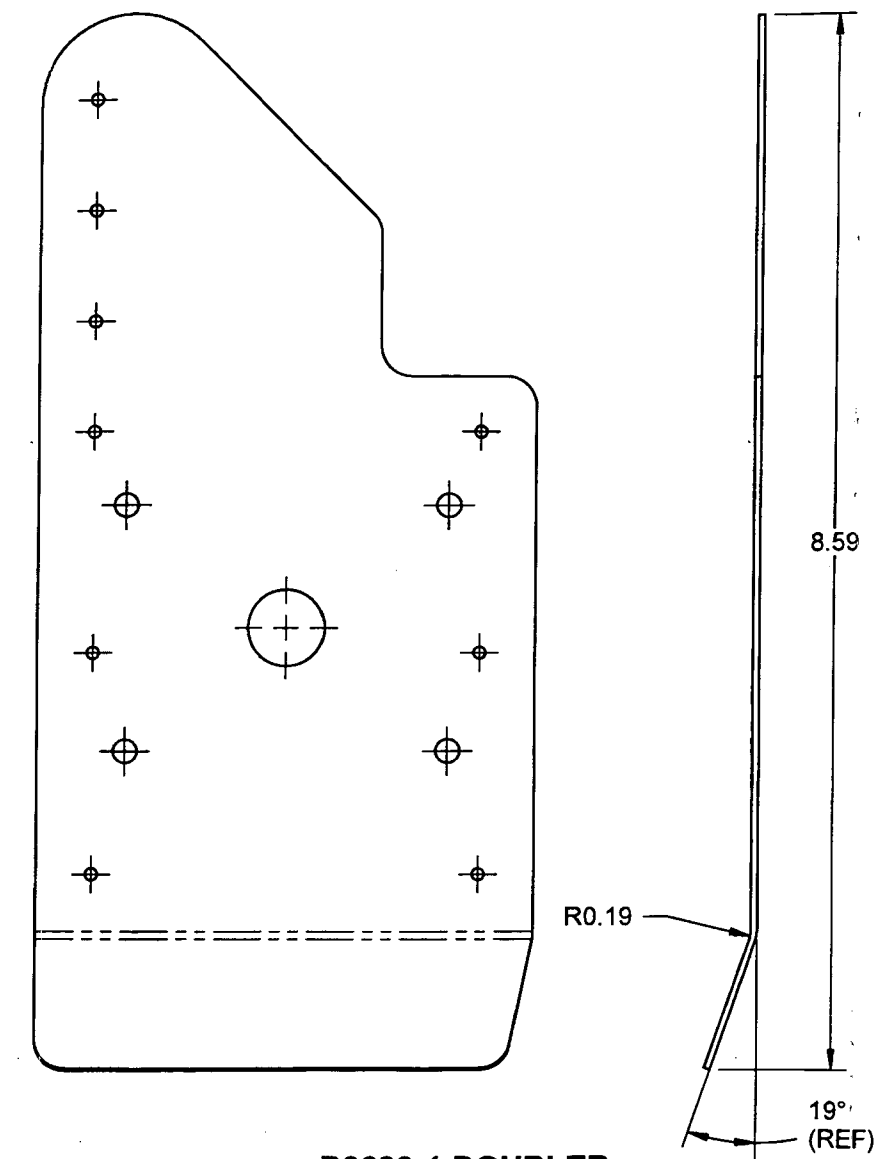
Measured by: AB	Audited by: ER	Prototype Approval: M/A
Date: 07-10-15	Date: 07/10/15	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

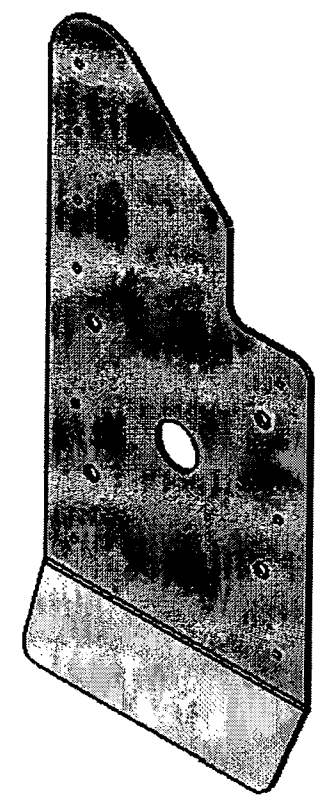
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D3639-1F FLAT PATTERN
(D3639-2F OPPOSITE)



D3639-1 DOUBLER
(WAS GENEVA P/N G10604-3)
D3639-2 OPPOSITE
(WAS GENEVA P/N G10604-6)



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A		NEW ISSUE; REPLACES G10604		LE	07.07.27
REV.		DESCRIPTION		BY	DATE
DESIGN	TS	DART AEROSPACE USA, INC. PORT HADLOCK, WA		REV. A SHEET 1 OF 2	
DRAWN	LE				
CHECKED	JB	DRAWING NO. D3639		SCALE 2:3	
MFG. APPR.	BE	TITLE DOUBLER			
APPROVED	NO				
DE APPR.					
DATE	07.07.27				

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